



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

9011
Dec 12

649.4816

Job Sheet 186017



Part No: 649.4816

Job Qty: 4 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: 649.4800 REV.E IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM IPP REV:B 17.10.18 AS PER REV.D DD VERF:JFS IPP REV:C 17.11.22 AS PER REV.D1 DD VERF:JFS IPP REV:D 17.11.23 ADD ROLL PART DD VERF:JFS IPP REV:E 18.03.14 PER DWG REV.E DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs	11/23/18	11/23/18	0.00	0.57	Waterjet - Flow		SC 18/11/15
120	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Waterjet-1		SC 18/11/15
130	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC8-1		38
140	Small Fab	4 pcs	11/23/18	11/23/18	0.00	0.50	Small Fab-9		38
150	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC5		38
160	Outsource	4 pcs	11/23/18	11/23/18			ATG001-VC	8	DEC 19 2018
170	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		DEC 19 2018
180	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC6		DEC 19 2018
210	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		JAN 02 2019
220	QC21-SA	4 Ea	11/23/18	11/23/18	0.00	0.00	QC21		JAN 02 2019

Part Op 110 - 1-Cut as per Dwg Dwg Rev: E Prog Rev: E 2-Deburr if necessary

Descriptions: 140 - FORM TO MAKE RAD AS PER DWG USE TOOL

160 - Issue P/O to ATG: 00041844 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.160	2024-T3 .160 Sheet	3.0480 sf (.762 ea)	110-Waterjet - Flow - 1	5054495

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.160	3	13	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NC _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____				MRB (QSI042) Approval	
				Disposition	
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Category ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			

DART AEROSPACE
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

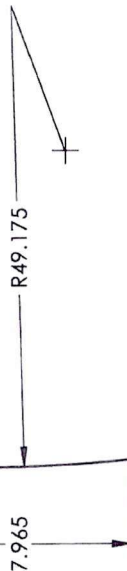
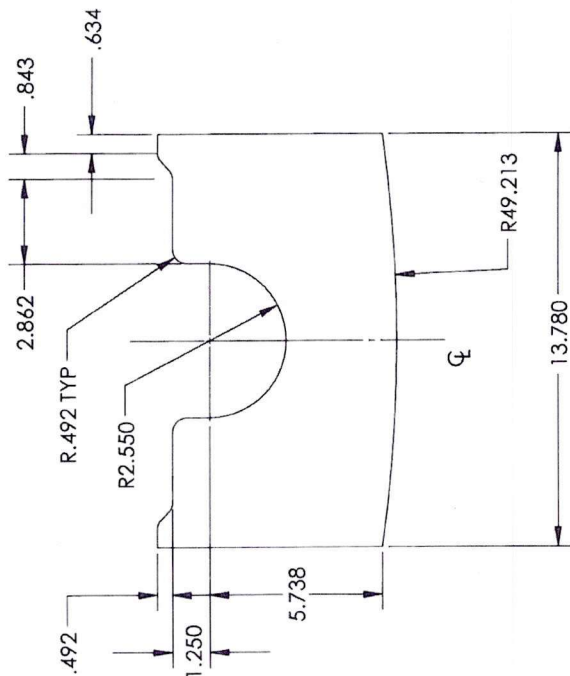
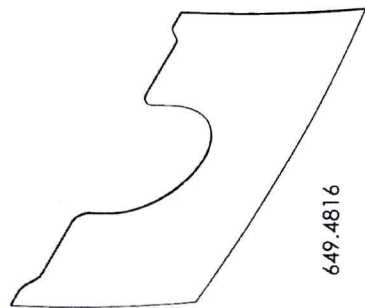
Container No: S128024
Part: 649,4816
Job No: 186017
Serial No/Batch: S128024
 Revision: E
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Date: 11/15/18

Equip/Tooling	Supplier	Centre Not Concentric	BOM/Route
Handling/Pre	Training	Cracks	Broken/Damage/Defect
Material	Use for Testing	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified
Internal Transport	Poor Information	Cuffs	Contamination
Tribal Knowledge	Rushing	Crushing	Countersink
LOA	Product Improvement	Heat Treat	Cut Too Short
Substation	Process Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear
Past Expiry Date	Manufacturing Process	Marks/Chatter	Drill Holes
Misidentified	Past Due	OTHER :	

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REV	DESCRIPTION	DATE	APPROVED



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186917
18-11-8

ORIGINAL DATE	18-11-8
APPROVED BY	18-11-8
A. QUAN	P. BRANO
DRAWING APPROVAL	18-11-8
CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
2 PLACE DECIMALS	
ANGLE ± 5°	
SCALE	NONE
DWG. NO.	649.4800
REV.	A
SHEET	5 OF 5

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

SHEETMETAL

Linda Lacelle

From: Linda Lacelle
Sent: Wednesday, November 7, 2018 11:21 AM
To: Patrick Duval; Caitlin Crooks
Cc: Jason Leroux; Jean-Luc Menard; Marc Bellavance
Subject: RE: 649.4701- rev C
Attachments: 649.4900 A1 CUTTER ASSY.pdf

Thx Pat
Pls see below

From: Patrick Duval
Sent: Tuesday, November 6, 2018 5:43 PM
To: Caitlin Crooks <ccrooks@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>
Subject: RE: 649.4701- rev C

Linda,
Here's a quick list of what I will need in order to make my kit to rev C.

649.5111 need some at rev A1 (got some in quarantine) – are these good to use?
649.5112 need some at rev A1 (got some in quarantine) – are these good to use?
649.4811 need some at rev A – WJ>OS – approx. 3wks
649.4816 need some at rev A – WJ>OS – approx. 3wks
649.4813 need some at rev A – WJ>OS – approx. 3wks
649.5214 need some at rev A – Machining>OS- approx. 4-5wks aro
649.5010 need some at rev C1 – Machining>OS- approx. 4-5wks aro
649.4902 need some at rev A – do the 649.5301 and 649.8301 need to be at an older rev? see attached

x 4 each

Rev A1

Also for me to complete the kit from RA173 we will need to add, remove some of the hardware to make it as per rev C.

Sorry for the delay... this is a big mess and I don't what to rush and ship something that's not good.

Pat Duval
QC Coordinator



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO041994**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041994

PO Date: 12/10/18

Due Date: 12/21/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ** each line has different date**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186254	646.3311	RH Half - Upper Cutter Assembly Issue P/O to ATG :	Firmed	-	12/19/18	12 pcs	0 pcs	12 pcs	\$19.41/pcs	\$232.92
Line Item Note ASAP: (											
2	184450	RBD29905-7	Bushing -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBD29905-7 Rev. 5	Firmed	-	12/17/18	30 pcs	0 pcs	30 pcs	\$4.03/pcs	\$120.90
3	185539	RBE105-13141W3-3	Plate -Issue P/O to ATG : ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT As Per Dwg RBE105-13141W3-3	Firmed	-	12/17/18	5 pcs	0 pcs	5 pcs	\$4.03/pcs	\$20.15

Plex 12/17/18 3:34 PM dart.tsimiklis.chrisoula



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PURCHASE ORDER **PO041994**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186017	649.4816	Doubler Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	12/21/18	4 pcs	0 pcs	4 pcs	\$31.31/pcs	\$125.24
5	184103	RBH9928- 12-3	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/14/18	12 pcs	0 pcs	12 pcs	\$4.03/pcs	\$48.36
6	187270	SWA3-300	Wire Clamp -Issue P/O to Groupe Atlech: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	12/18/18	43 pcs	0 pcs	43 pcs	\$3.21/pcs	\$138.03

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PURCHASE ORDER
PO041994

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	187046	647.7913	Doubler Issue P/O ATG, black anodize and prime as per dwg 647.7913 Rev. A	Firmed	-	12/17/18	8 pcs	0 pcs	8 pcs	\$4.03/pcs	\$32.24

Grand Total:	\$717.84
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Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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